

What is claimed is:

1. A siphonable filler tube valve assembly comprising:
 - (a) a generally tubular body with an inlet end adapted for receiving fuel upon refueling through the filler tube and an annular valve seat therein downstream of the inlet and an end distal said inlet end for attachment to a fuel tank spud;
 - (b) a poppet moveable between a position closing and a position opening said valve seat including means operable for biasing said valve to the closed position;
 - (c) an outlet opening formed in the wall of said body downstream of said valve seat;
 - (d) said poppet including surfaces operable to direct the end of a siphon hose inserted through said inlet end and said valve seat outwardly through said outlet as said siphon hose moves the poppet to the open position; and,
 - (e) said poppet having an annular flexible seal overmolded thereon for sealing against said valve seat.
2. The valve assembly defined in claim 1, wherein said surfaces operable to direct the end of a siphon hose include surfaces selected from one of flutes and vanes.
3. The valve assembly defined in claim 1, wherein said body includes a plurality of raised surfaces disposed about a portion of the interior upstream of said valve seat, and operable to deflect said end of a siphon hose toward one side of said poppet and toward said outlet opening.
4. The valve assembly defined in claim 1, wherein said overmold is formed of elastermeric material.

5. The valve assembly defined in claim 4, wherein said over mold is formed of fluorosilicone elastomer.
6. The valve assembly defined in claim 1, wherein said body includes a plurality of circumferentially spaced outlet openings formed in the wall downstream of valve seat.
7. The valve assembly defined in claim 1, wherein said poppet includes guide surfaces thereon slidably engaging corresponding surfaces on said body and operable to prevent relative rotation of said poppet with respect to said body.
8. The valve assembly defined in claim 1, wherein said poppet is formed of plastic material.
9. The valve assembly defined in claim 1, wherein said poppet includes a centrally disposed guide post slidably guided within said body.
10. The valve assembly defined in claim 1, wherein said poppet includes turbulence reducing surfaces formed on an upstream side thereof.
11. The valve assembly defined in claim 1, wherein said body distal end includes a member having surfaces thereon for snap engagement with a tank spud.
12. The valve assembly defined in claim 1, wherein said body distal end includes a guide member snap-locked thereon.

13. A method of making a filler tube valve comprising:
 - (a) forming a tubular body having an inlet in one end thereof and forming an outlet opening in the wall thereof and forming an annular valve seat intermediate the inlet and outlet opening;
 - (b) forming a poppet and overmolding elastomeric material thereon and forming annular sealing surface on the poppet with said overmolding;
 - (c) disposing said poppet in said body for movement therein and biasing said poppet in a direction to seat said annular sealing surface against said valve seat; and,
 - (d) forming deflecting surfaces on the upstream side of said poppet for directing the end of a siphon hose through said outlet opening.
14. The method defined in claim 13, wherein said step of forming deflecting surfaces includes forming turbulence reducing surfaces.
15. The method defined in claim 14 herein said step of forming turbulence reducing surfaces includes forming a plurality of fins.
16. The method defined in claim 13, wherein said step of forming a poppet includes forming an annular groove for said overmolding.
17. The method defined in claim 13, wherein said step of biasing said annular sealing surface includes disposing a coil spring in contact with said poppet.
18. The method defined in claim 13, wherein said step of forming an outlet opening includes forming a plurality of openings.

19. The method defined in claim 13, wherein said step of forming a tubular body includes forming a plurality of deflecting vanes internally and upstream of said valve seat.
20. The method defined in claim 13, wherein said step of forming a poppet includes forming a poppet of plastic material.
21. The method defined in claim 20, wherein said step of forming a poppet includes forming a poppet of acetyl material.
22. The method defined in claim 13, wherein said step of forming a poppet includes forming a centrally disposed guide post and slidably guiding said post on said body.
23. The method defined in claim 13, wherein said step of forming a poppet includes forming surfaces on an upstream side thereof for reducing turbulence.
24. The method defined in claim 23, wherein said step of forming surfaces for reducing turbulence includes forming a plurality of fins.